

Date: Monday, 7/9/2007 2:29:14 PM
User: Kim Johnston

Process Sheet

5817

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG EXTRUSION
Job Number	: 33420 -2	Part Number	: D27317
Estimate Number	: 10326	Drawing Number	: D2731 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 7/9/2007 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 7/20/2007
Previous Run	: 33136	Qty:	50
Written By	: [Signature]	Um:	Each
Checked & Approved By	: [Signature] 07.07.10		
Comment	: Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s)
Lug Extrusion D2423
Batch: B23779

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut D2423 extrusion to .82" Batch _____

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

RG



Issue fo 4191



Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine as per folio D2731-7.
2-Check for crack while loading into the machine.
3-Tumble
4-Deburr any rough edges after tumbling
Machine per ~~std~~ drawing D2731 Rev.B

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

RG



Receive & Inspect for transit damage



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC5	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK Inspect level 5

En 07/08/27 (50)

center

(50)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 33420

Part Number: D27317

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR

0708-31

(50)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M 105068

BR

07-09-04

(50)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EP 07/09/10 (50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/09/10 (50)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

EP 07/09/11

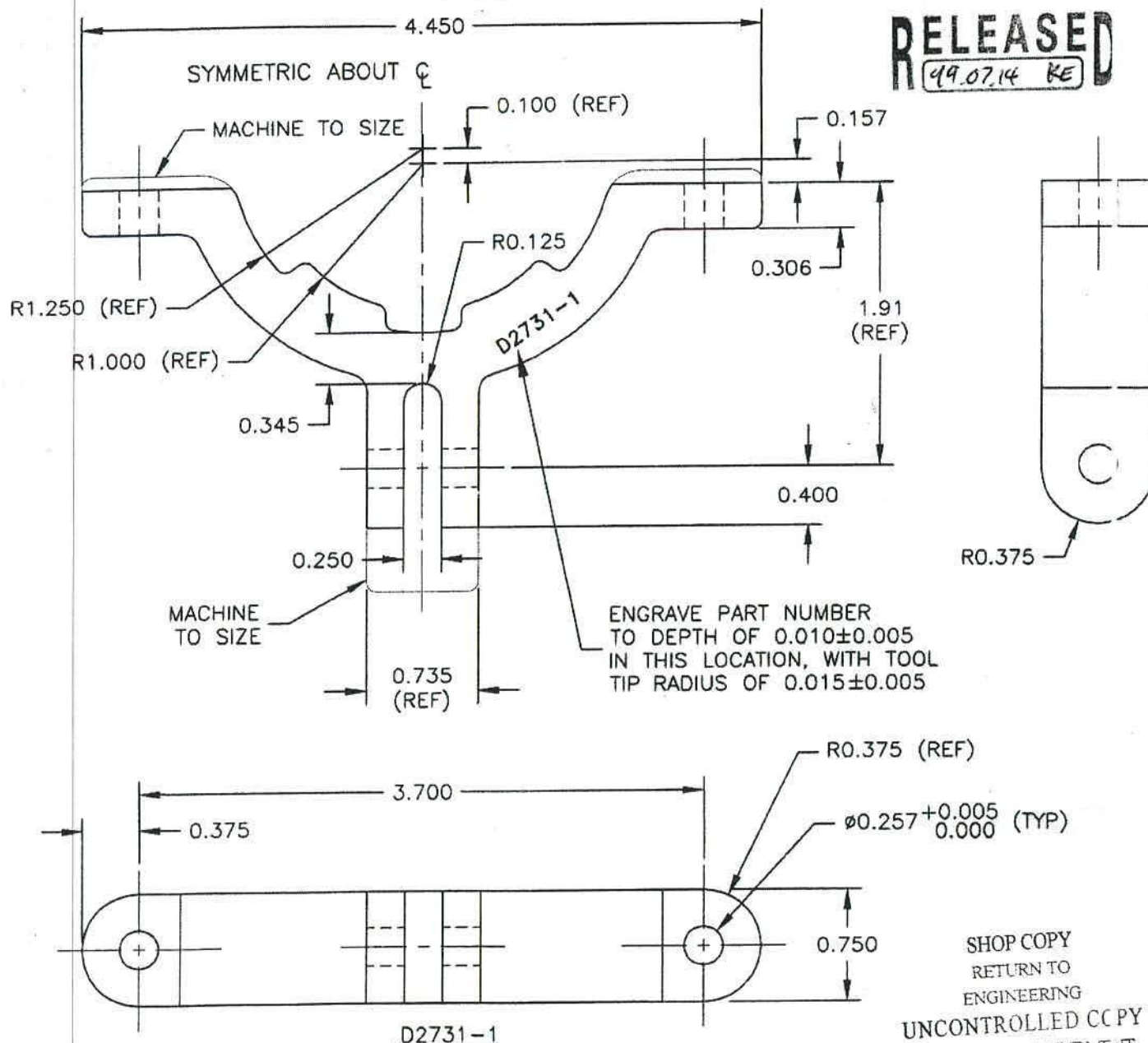
Job Completion



W 0729-11

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	



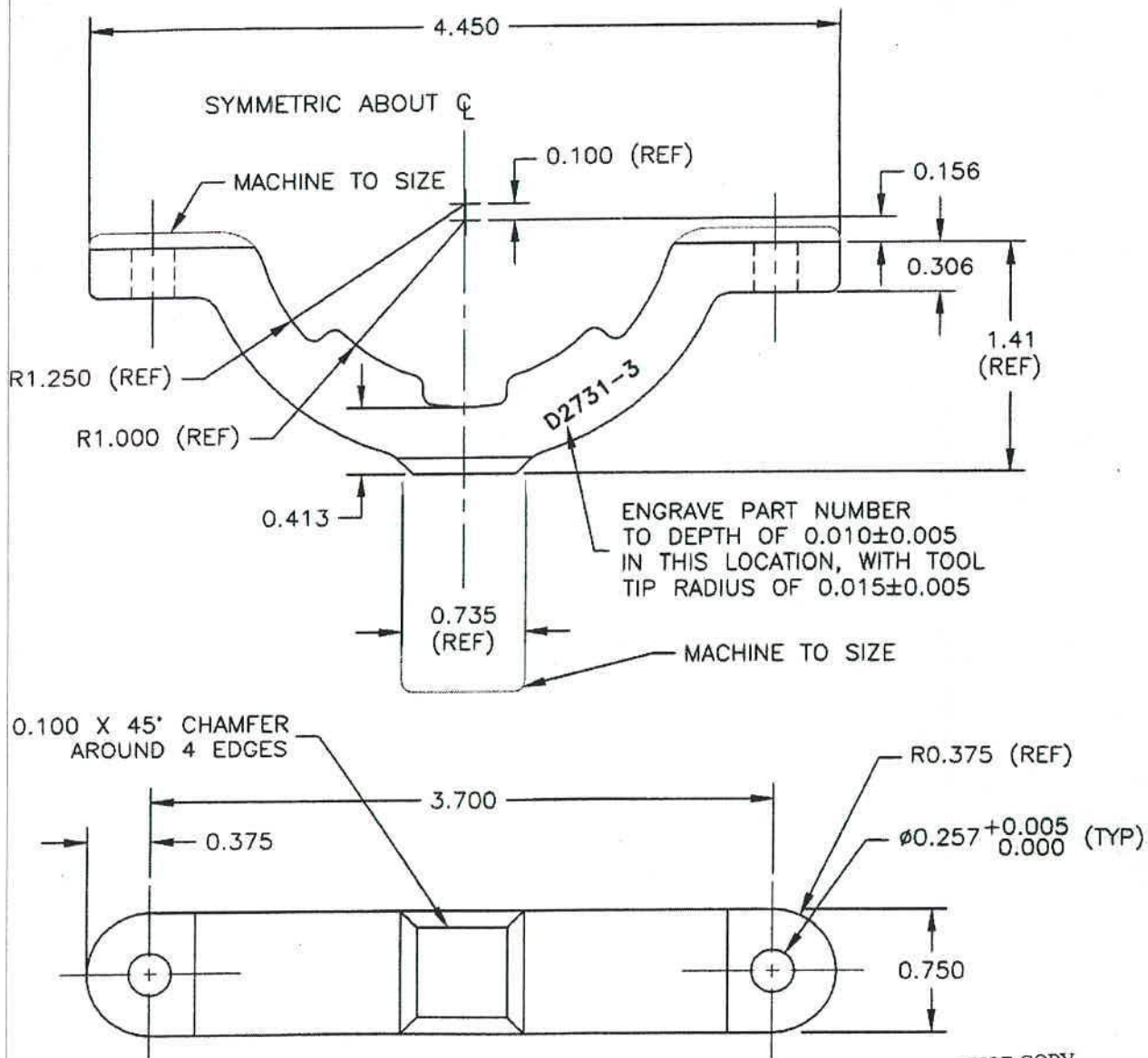
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33426



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 2 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*

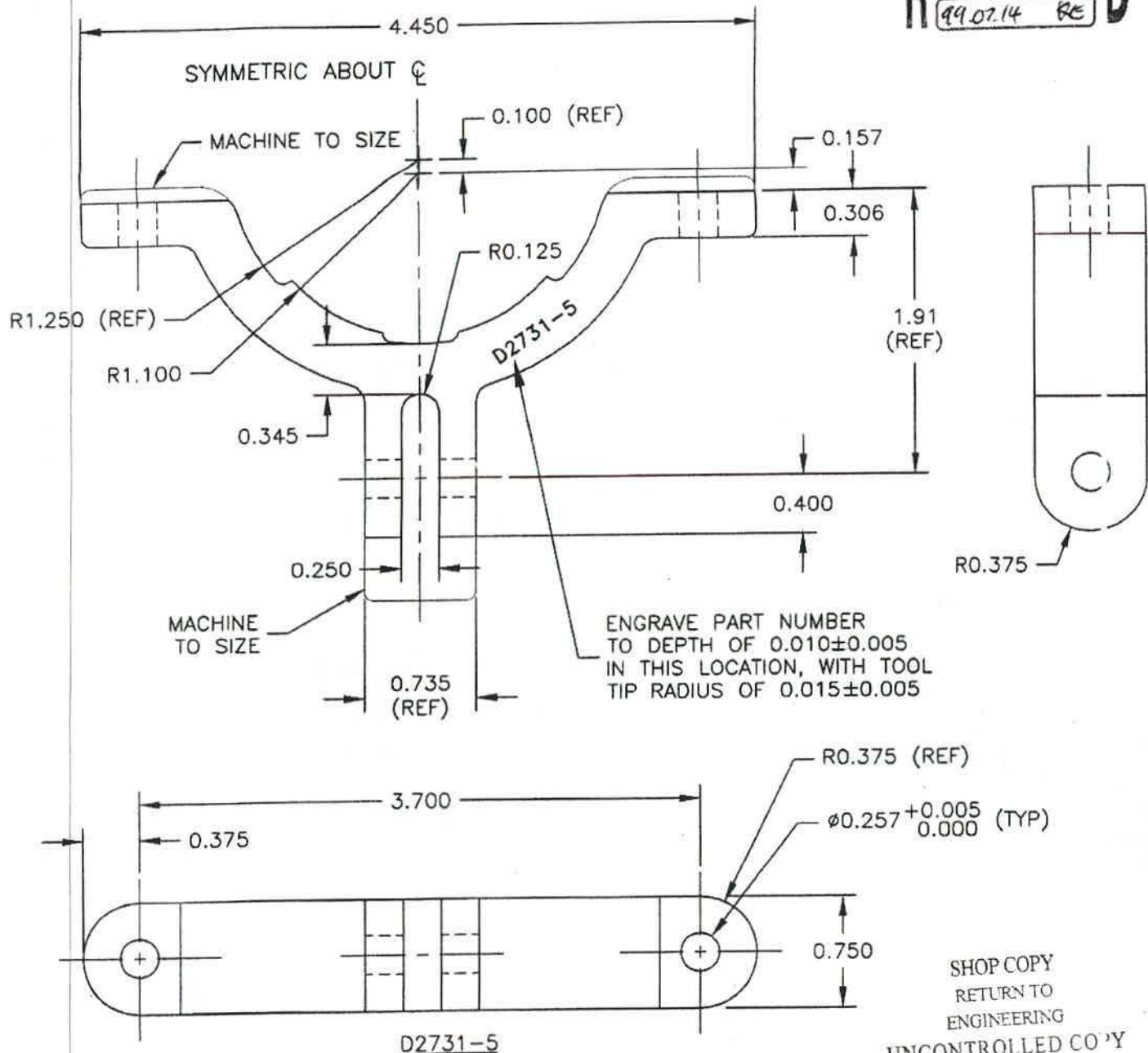


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 33420

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2731	REV. B SHEET 3 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

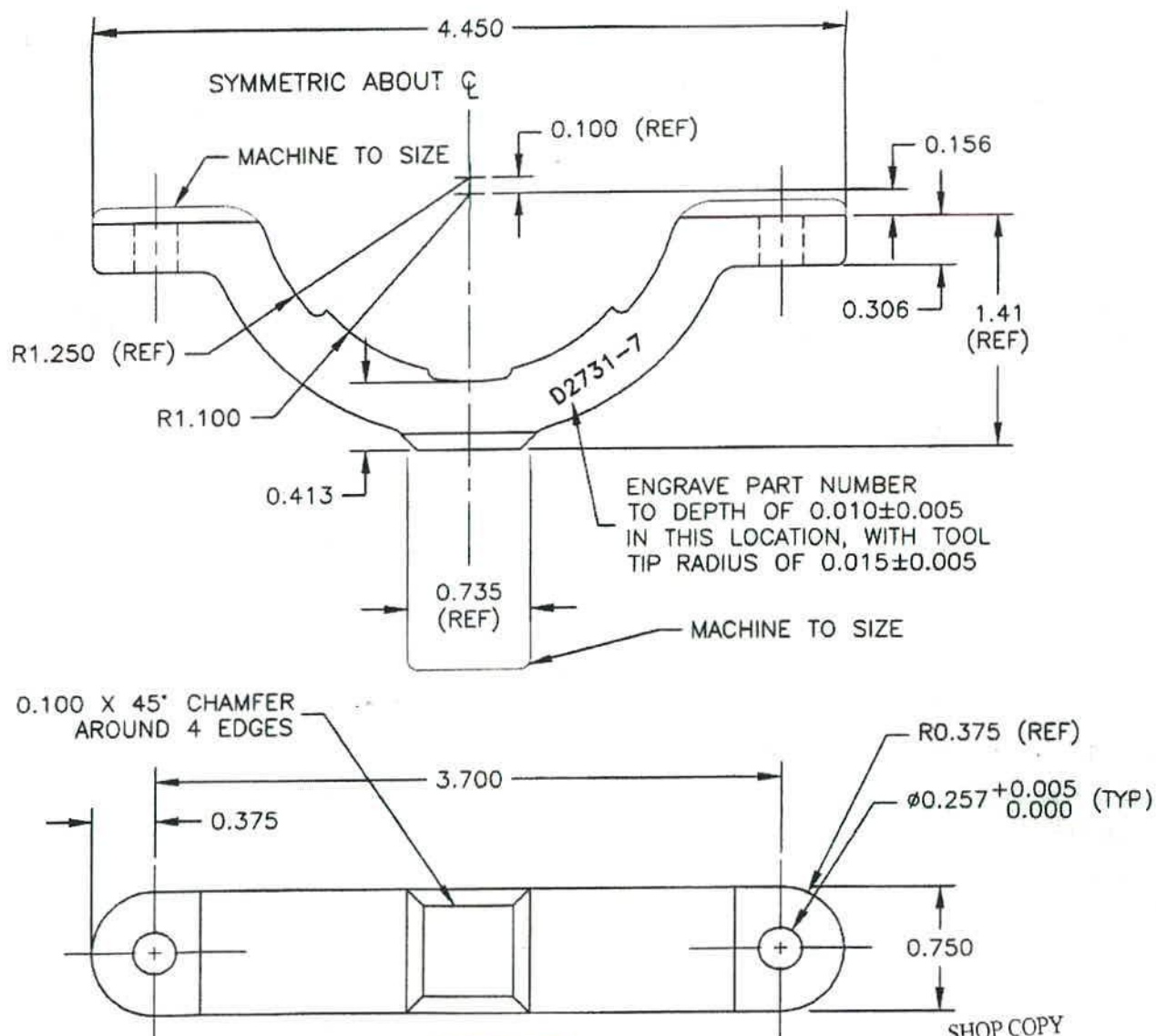
RELEASED
99.07.14 *RE*

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 NO. 33420
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER



RELEASED
99.07.14 KL



D2731-7

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
ED NO. 33420

**CERTIFICATE OF CONFORMITY**

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
32	D2731-7	Lug B33420	4191
	MATERIAL: supplied by DART D2423 B23779		
18	D2731-7	Lug B33420	4191
	MATERIAL: supplied by DART D2423 B30062		

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi Walz".
Shigi Walz

Vankleek Hill, August 23, 2007